

Date: Tuesday, 9/12/2006 1:12:46 PM  
 User: Kim Johnston

## Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	X-TUBE AS 350/355 HI AFT
Job Number :	28464A	Part Number :	D350748241
Estimate Number :	12483	Drawing Number :	D350-748-241
P.O. Number :		Project Number :	N/A
This Issue :	9/12/2006 S.O. No. :	Drawing Revision :	C UNDER REVIEW <i>06.09.13</i>
Prsht Rev. :	NC	Material :	
First Issue :	1/1 Type : LANDING GEAR	Due Date :	10/25/2006 Qty: 1 Um: Each
Previous Run :	28463A		
Written By :	<i>06.09.12</i>		
Checked & Approved By :			
Comment :	Est Rev: A New Issue 06-07-05 JLM Est Rev: B Update cadplate process 06-09-12 KJ		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D350-748-241 CHG001

2.0	D6018125	Crosstube Material
-----	----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Crosstube Material

D6018-125

2.299" OD-X 2.000" ID

Batch: *27472*

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs on both ends as per Folio FA647

2-Turn first side as per Folio FA647

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D350-748-241

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------



Comment: INSPECT ALL DIM TO DIM SHEET

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/12/2006 1:12:46 PM  
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Drawing Name: X-TUBE AS 350/355 HI AFT

Job Number: 28464A

Part Number: D350748241

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA647

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D350-748-241.

3-Scribe part # as per Dwg D350-748-241

BG 06-09-15 1

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

BG 06-09-15 1

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.6 06/09/19 1

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Remove all Machining Marks

DP 6-9-25

9.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 2129

C 20609124 0

Heat Treat to min 180 KSI As per Dwg D350-748-241

Sand Blast tube after Heat Treat

Possible Supplier: Vac Aero

Ensure Certificate of Conformity is attached

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformaty is attached

PC 9/10/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI AFT

Job Number: 28464A

Part Number: D350748241

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC6

DIMENSIONAL CHECK



*206-10-19 (1)*



Comment: DIMENSIONAL CHECK

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Oil inside of tube with LPS-3 .

A/R LPS-3 Batch: \_\_\_\_\_

13.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D350-748-241 using CNC bender program D350A and Folio FT

*DP 6-10-30*

14.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

15.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Remove all marks from tube within limits of D350-748-241

2-Drill Tube as per Dwg D350-748-241 Using DT8876 Drill Jigs,  
Set-up drill table as per QSI 010

3-Deburr

4-Engrave Part # and Batch # as per Dwg D350-748-241



16.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: \_\_\_\_\_

Stress relief at 375° for 5 hours

Magnetic Particle Inspect per ASTM E1444

Cadium Plate per QQ-P-416F, Class 1, Type 2

Embrittle relief at 375° for 8 hours, Chromate Treat

Possibe Supplier: Southwest United Industries

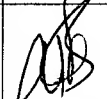


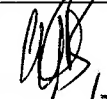

Ensure Certificate of Conformity is attached

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/2-05	13.0	Tube SCRAP 1/2 SPANS have 2" difference and are over bent on each side. Bend development for folio's.	 07/01/17	Scrap: destroy.	 2-1-17	 10/01/17	 07/01/17	 06/12-05

NOTE: Date & initial all entries

Date: Tuesday, 9/12/2006 1:12:46 PM  
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Drawing Name: X-TUBE AS 350/355 HI AFT

Job Number: 28464A

Part Number: D350748241

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

19.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside crosstube as per QSI 005 4.2

2-Paint Outside of Tube as per Dart QSI 005 4.2

20.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

21.0

D35021

SUPPORT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

SUPPORT

Batch: \_\_\_\_\_

22.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2401 f(s)/Unit Total: 1.2401 f(s)

Abrasion Strip 7.10" long x2

Batch: \_\_\_\_\_

23.0

ALS41032225

Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Insert

Batch: \_\_\_\_\_

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 28464A

Part Number: D350748241

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN960JD10

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

Batch: \_\_\_\_\_

25.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp (per MIL-DTL-8783C)

Batch: \_\_\_\_\_

26.0

MS27039110

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Screw

Batch: \_\_\_\_\_

27.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install Ground wire Insert, then insert screw and washer

2-Install Abrasion strips as per Dwg D350-748-241 & QSI 035.

3-Install supports Using Dt8876 as per Dwg D350-748-241, Torque to 60-80 IN-LBS

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-748-241

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI AFT

Job Number: 28464A

Part Number: D350748241

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07-03-12

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>QD</i>	DRAWN BY <i>QD</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D350-748-241	REV. C SHEET 1 OF 3
DATE 06.08.14		TITLE CROSSTUBE (AS 350/355 HI AFT) NTS	
A	06.03.31	NEW ISSUE	
B	06.06.30	ADD D6018-125 & PRIME AND PAINT	
C	06.08.14	ADD CAD PLATING	

**UNDER REVIEW***QD 06.08.14*CAD PARTIAL PROCEDURE  
WEEK 1 CHANGE

QTY	P/N	DESCRIPTION
X	D350-748-241	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
1	D6018-125	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
1	MS27039-1-10	SCREW

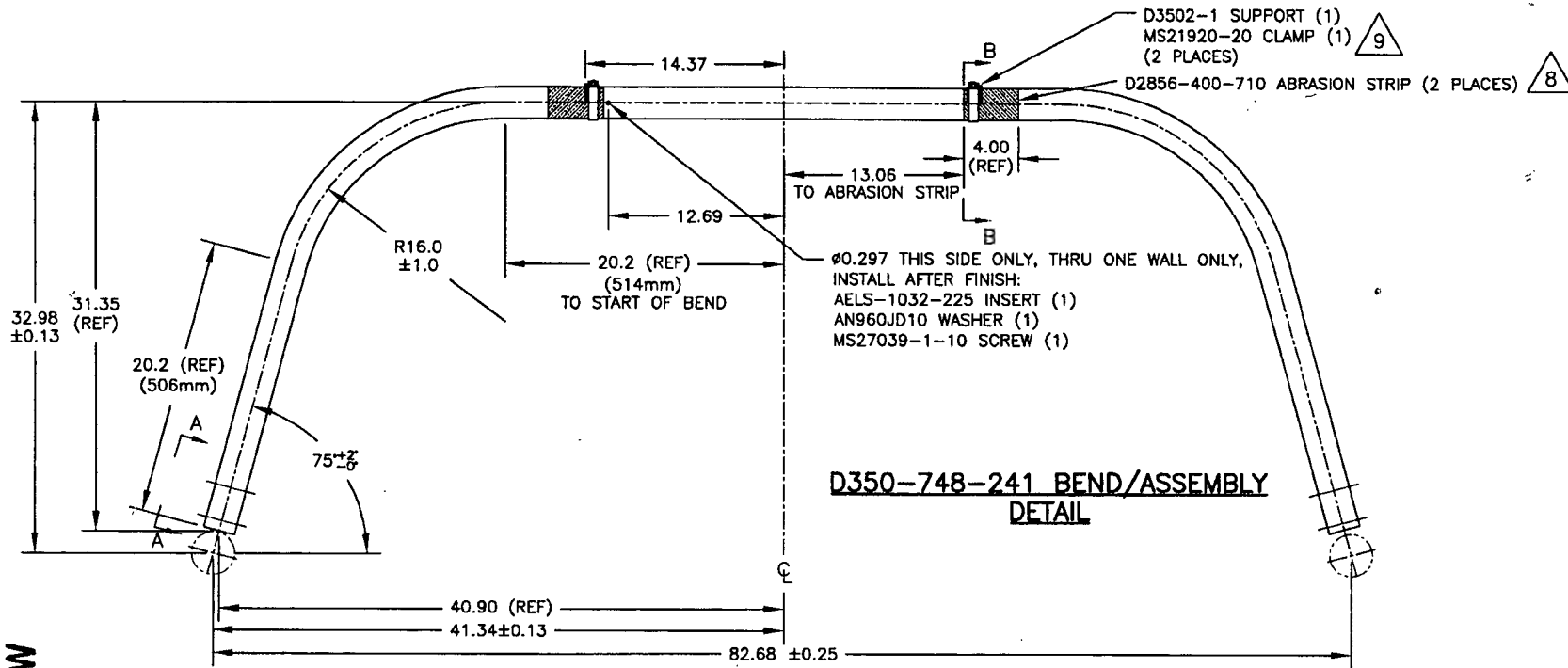
**D350-748-141 CROSSTUBE:**

- 1) MATERIAL: MANUFACTURED FROM D6018-125 OR D6015-125  
FINISHED LENGTH =  $122.70 \pm 0.06$
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING
- 6) FINISH: CADMIUM PLATE PER QQ-P-416F, CLASS 1, TYPE II  
MAGNETIC PARTICLE INSPECT PER ASTM E1444 AFTER CADMIUM PLATING  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR  $\varnothing 0.297$  HOLE.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
28464A  
RELEASED  
06.08.15 *#*

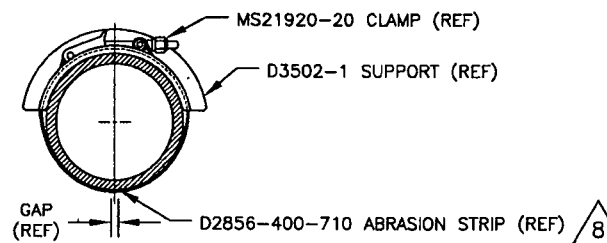
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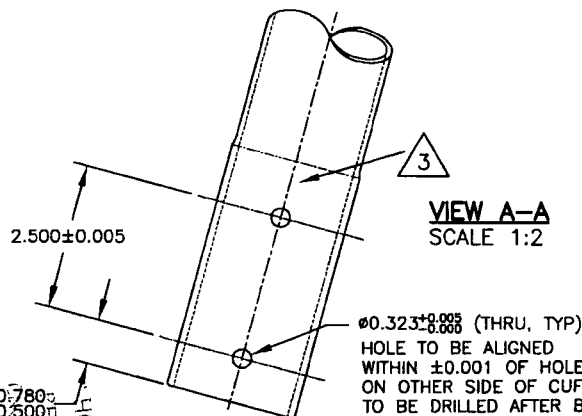
**D350-748-241 BEND/ASSEMBLY  
DETAIL**

**SECTION B-B  
SCALE 1:2**



**RELEASED**

06-08-15

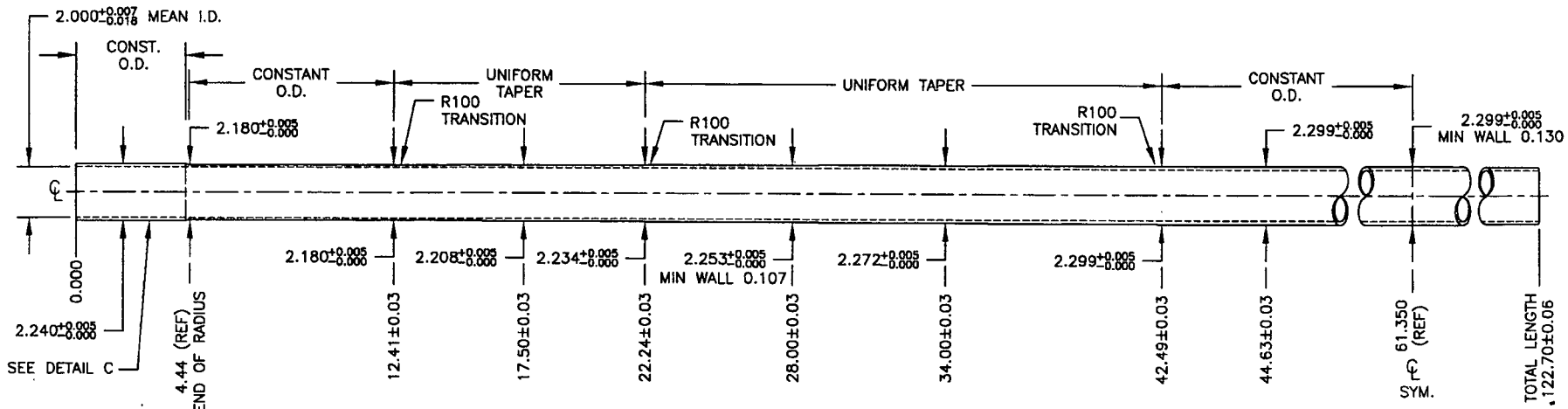


**VIEW A-A  
SCALE 1:2**

COPYRIGHT © 2008 BY DART AEROSPACE LTD.		DESIGN 9P	DRAWN BY 9P	<b>DART</b> DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA	REV. C  SHEET 2 OF 3	
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		DATE 06.08.14	TITLE CROSSTUBE (AS 350/355 HI AFT)			SCALE 1:8

**UNDER REVIEW**

NO WORK ORDER  
881664A  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
RETURN TO  
ENGINEERING  
06780-00000  
HOP COPY



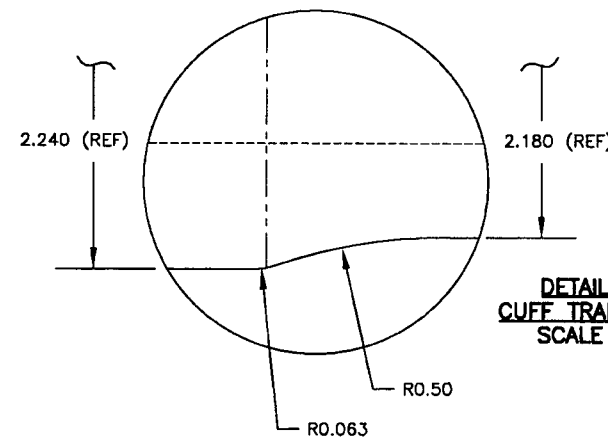
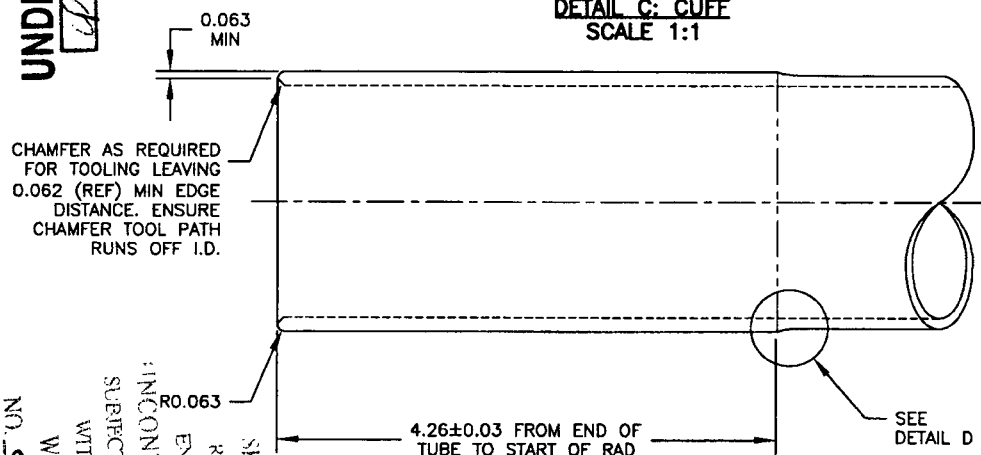
UNDER REVIEW

RELEASED

06.08.15

# D350-748-241 MACHINING DETAIL

DETAIL C: CUFF  
SCALE 1:1



DETAIL D:  
CUFF TRANSITION  
SCALE 9:1

NO. 284644

WORK ORDER

ENGINEERING

RETURN TO

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SUBJECT TO AMENDMENT

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DATE		06.08.14		DRAWING NO.	REV. C
				D350-748-241	SHEET 3 OF 3
				TITLE	SCALE
				CROSSTUBE (AS 350/355 HI. AFT)	1:4

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 28464 A
<b>Description:</b> 350 X-TURBIE		<b>Part Number:</b> Q350-748-241
<b>Inspection Dwg:</b> 350-748-241 Rev: C		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.240	$\pm .005$ $-.000$	2.244	—			
2.180	"	2.185	—			
2.180	"	2.185	—			
2.208	"	2.213				
2.234	"	2.238				
2.253	"	2.255				
2.272	"	2.276				
2.299	"	2.304				
4.26	$\pm .030$	4.27				
.063	$\pm .010$	.063				
122.7	$\pm .06$	122.7				
2.240	$\pm .005$ $-.000$	2.244				
2.180	"	2.185				
2.180	"	2.185				
2.208	"	2.213				
2.234	"	2.238				
2.253	"	2.256				
2.272	"	2.276				
2.299	"	2.303				
4.26	$\pm .03$	4.26				
.063	$\pm .010$	.063				

<b>Measured by:</b> BC	<b>Audited by:</b> J.G	<b>Prototype Approval:</b>
<b>Date:</b> 06.09.15	<b>Date:</b> 06/09/19	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	







# VAC AERO

INTERNATIONAL INC.

## RELEASE NOTE

GST No.: R105468102

OAK 79915-1



HEAD OFFICE  
1371 SPEERS ROAD, OAKVILLE, ONTARIO  
CANADA L6L 2X5  
TEL: (905) 827-4171 FAX: (905) 827-7489



2009 WYECROFT ROAD, UNIT B  
OAKVILLE, ONTARIO  
CANADA L6L 6J4  
TEL: (905) 827-7377 FAX: (905) 827-1380



QUEBEC DIVISION  
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC  
CANADA H4S 1C5  
TEL: (514) 334-4240 FAX: (514) 334-6269

10/11/2006

MM / DD / YYYY

PAGE: 1

BILL TO: 1DAR01  
DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
10/11/2006		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
PO00002129		COD

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D350-CROSS TUBES	EA 10 10				
<p>Process Specifications: Procedure: 4353 HEAT TREATED TO 180-200 KSI PER AMS 2759-1C 100% HARDNESS TESTED PER ASTM E-18 HRC 40-43 MATERIAL: 4130</p> <p>5 PCS. P/N: D350748141 B28459, B28460, B28458, B28466, B28461 5 PCS. P/N: D350748241 B28162, B28464, B28465, B28463, B28471</p> <p>SANDBLASTED AFTER HEAT TREAT</p>					
<div>100% HARDNESS TESTED 10 PCS. 42/43 HRC</div> <div>VALQ TH. 25 Q.C.</div>					

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

*Laura Freeman*  
Authorized Q.C. Inspector

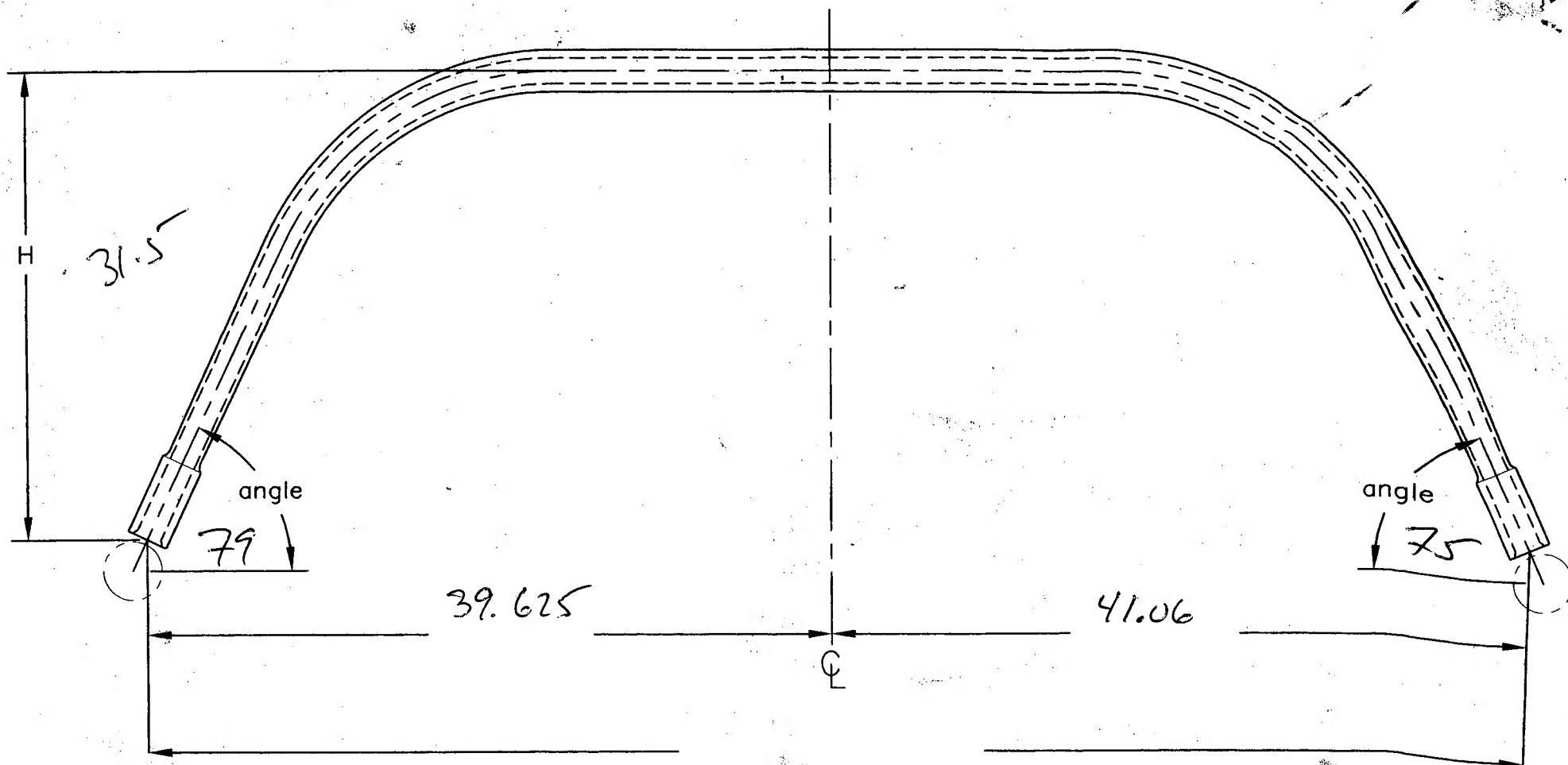


HEAT TREATING



VACUUM BRAZING · HEAT TREATING · SPECIAL PROCESSING · FURNACE EQUIPMENT





DATE: 06.12.05

DESCRIPTION: 350-748-241

BATCH NO: 28464

DRAWING: 350-748-241 Rev - under review dims at Rev e

H: 31.35 }  $\pm .13$

1/2 SPAN: 40.90

TOTAL SPAN: 81.8

ANGLE: 75  $\pm .1$

SCVAP.